

# Work Order ID 81362

**\*81362\***

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Item ID: D3537-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearpad  
 Start Date: 13/03/2012 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 27/03/2012 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								

100 FLOW WATER JET 0.00  
**\*100\***  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr  
304-063 if necessary

B12-3-08

(62)

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

B12-3-05

120 QC8- Inspect parts - second check 0.00  
**\*120\***  
 QC Memo 0.00  
 Quality Control

8/2/03/16

062

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*81362\***

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** Wearpad

**Start Date:** 13/03/2012      **Start Qty:** 50.00

**\*50\***

**Cust Item ID:**

**Required Date:** 27/03/2012      **Req'd Qty:** 50.00

**\*50\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:**      **Date:**      **Tooling:**      **Date:**

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

### Operation Description

## Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

**\*130\***

NC BRAKE

0.00

Brake NC

## Memo

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-  
Identify as D3537-1

140

0.00

**\*140\***

## Large Fab

0.00

Large Fab

## Memo

## Large Fab

Qty.	Description	Batch A/R	2059B Hardcoat
12/33	1-Weld as per Dwg D3537 using Jig DT 82102-Remove any weld that penetrated through Wearpad if necessary		

150

QC10- Inspect visual per QSI004- ground welds

0.00

**\*150\***

## Memo

0.00

QC

### Quality Control.

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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 Required Date: 27/03/2012 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC5- Inspect part completeness to step on W/O 0.00

**\*160\***

QC

Memo

Quality Control

170 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

**\*170\***

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

180 QC3- Inspect Part Finish 0.00

**\*180\***

QC

Memo

Quality Control

Curly  
62

62 X

M/L  
12/05/07

62 X

12/05/07

M 117338

9:00  
9:30 320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <i>FP-2</i>	0.00							
<b>*190*</b>									
Packaging	Memo	0.00				62	4		BLD-5-7
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

*12/5/17*  
*ME*  
*12-05-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 81362

\*81362\*

Parent Item: D3537-1

\*D3537-1\*

Parent Item Name: Wearpad

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	254.4860	0.106	5.578947			

\*M304S16GA\*

304/316 Sheet .063

\*\*

7,  
B12-3-05

Location

Loc Qty

Loc Code

MAT020

254.486

119653

17.35

120866

78

120877

159.136

\_\_\_\_\_  
\_\_\_\_\_  
120877

(62)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

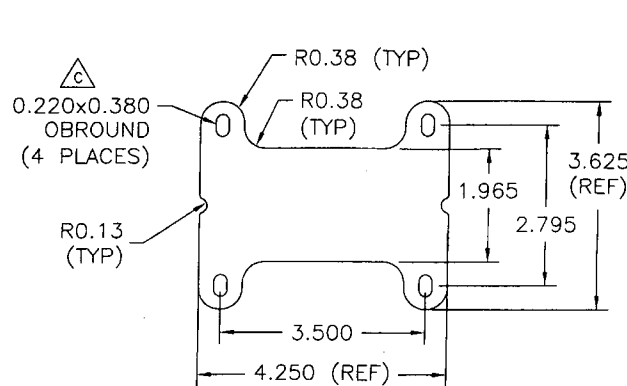
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

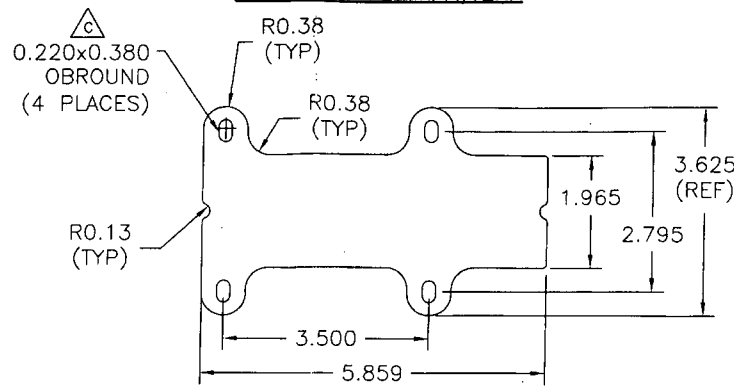
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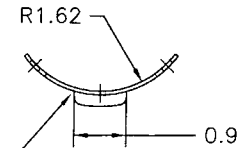
### D3537-1F FLAT PATTERN



### D3537-3F FLAT PATTERN

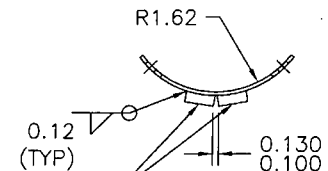


### SECTION A-A



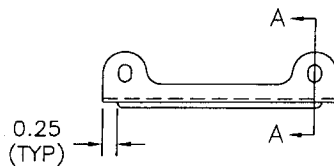
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

### SECTION B-B

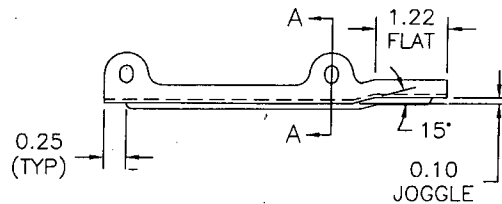


D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

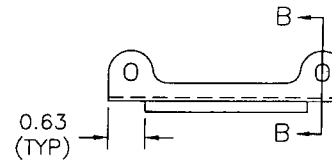
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



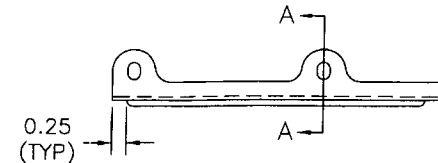
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY
CHECKED	#	APPROVED
DATE	07.04.13	TITLE
		WEARPAD
		DART AEROSPACE USA, INC. FORT HADLOCK, MA
		DRAWING NO. D3537
		REV. C SHEET 1 OF 1
		SCALE 1:2

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

81362 MLJ  
12/03/13

UNDER REVIEW  
07.05.08 PM  
per ECA  
962  
RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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